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D2154
Job Sheet 183856



Part No: D2154

Job Qty: 8 ea

Part Name: Bracket, Stud



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/27/18

Job Tracking No:

Due Date: 10/5/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV C IPP: C 03.08.08 Reform:at; Remove Tumble KJ/RF IPP Rev:D NowOn Waterjet 07-04-09 JLM
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet	8 pcs		10/5/18	0.00	0.37	Waterjet 1		SC 18/09/18
120	QC	8 pcs		10/5/18	0.00	0.00	QC8		
140	Brake NC	8 pcs		10/5/18	0.01	0.20	Brake NC 2		
150	QC	8 pcs		10/5/18	0.00	0.00	QC5		
160	Powdercoat	8 pcs		10/5/18	0.00	0.09	Powdercoat2		
170	QC	8 pcs		10/5/18	0.00	0.00	QC3		
180	Packaging	8 pcs		10/5/18	0.00	0.00	Packaging3-1		
190	QC21-SA	8 Ea		10/5/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg D2154

Descriptions: 140 - Form as per Dwg D2154

160 - START TIME: 11:45 FINISH TIME: 12:15 OUT: 4000. M13897

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.2664 sf (.0333 ea)	100-Waterjet	5106178

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet	M304S16GA	0	274	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket, Stud	2.250Inches ± 0.010	2.260 2.240	2.250	
2	Bracket, Stud	1.438Inches ± 0.010	1.448 1.428	1.440	
3	Bracket, Stud	0.406Inches ± 0.010	0.416 0.396	0.405	
4	Bracket, Stud	1.778Inches ± 0.010	1.788 1.768	1.780	
5	Bracket, Stud	2.128Inches ± 0.010	2.138 2.118	2.130	
6	Bracket, Stud	0.325Inches ± 0.010	0.335 0.315	0.323	
7	Bracket, Stud	0.203Inches + 0.005 - 0.001	0.208 0.202	0.203	Diameter
8	Bracket, Stud	0.063Inches ± 0.010	0.073 0.053	0.057	
9	Bracket, Stud	0.320Inches + 0.006 - 0.001	0.326 0.319	0.320	Diameter

Plex 9/27/18 2:21 PM Dart.Gagnon.Michelle

Entered:

Date:

NCR No. 19-7203

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



Route update only

Job: 183856
Part No. D2154

DISPOSITION

Rework ☐
Scrap ☒
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐
Cross tube ☐
Small Fab ☒
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐
Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: 19-02-25

Sequence #: 140

QTY Affected: 1

Description Work Order Deviation

Disposition

bracket height .88" is .925"

Scrap destroy no replace

MRB (QS042)

19-02-25

Completed By

19-02-25

Lead hand / Supervisor

19-02-25

QC / QA Coordinator

19-02-25

Root Cause

Operator ☒
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced ☐
Bending ☒
Crushing ☐
Cracks ☐
Crimp/Kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐
Other/Details: ☐
Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐

Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐

Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐